



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5951
Job Sheet 168451



Part No: D5951

Job Qty: 1 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:E Re-Format 05-11-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/17	0.00	0.00	Start Up Machining		17-11-15
100	CNC Vertical Machining	1 pcs		11/16/17	0.54	3.03	HAAS 1		17-11-15
110	QC	1 pcs		11/16/17	0.00	0.00	QC1		17-11-15
120	QC	1 pcs		11/16/17	0.00	0.00	QC8		17-11-17
130	HandFinish	1 pcs		11/16/17	0.00	0.08	HandFinish1		2017-11-20
140	Powdercoat	1 pcs		11/17/17	0.00	0.05	Powdercoat1		BR 11-20
150	QC	1 pcs		11/17/17	0.00	0.00	QC3		38
160	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging3	37	38
170	QC21-SA	1 Ea		11/17/17	0.00	0.00	QC21		NOV 21 2017

Part Op 100 - 1-Machine as per folio D5951 Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble
Descriptions: 140 - START TIME: 0.1.520° FINISH:

M B 8014

DAS
21
8-59

NOV 21 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-013	1	8	0	0
	<u>8148161</u>	<u>1.0</u>			

Part Specifications

Specifications could not be found.

Plex 11/14/17 3:12 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

DART AEROSPACE LTD		Work Order:	168451
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.438					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		0.316					
H	1.522	1.532		1.527					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.315	0.322		0.316					
L	0.495	0.505		0.500					
M	0.490	0.510		0.505					
N	1.615	1.635		1.625					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.310					
R	0.760	0.765		0.760					
S	0.490	0.510		0.502					
T	1.375	1.395		1.375					
U	2.000	2.020		2.000					
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: K.P.	Audited by: [Signature]
Date: 17-11-15	Date: 17/11/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE

S009909



Saddle

D5951

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 11/14/17
Job No: 168451